

Work Order ID 50260

July 14, 2009 10:47:43 AM



Page 1

Item ID: D3547-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Bracket

Start Date: 7/15/09 Start Qty: 6.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: mf

Date: 09-07-15

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3547

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3547 ☒ Dwg Rev: A ☐ Prog Rev: A

11

****Ensure Grain Direction is Correct**** ☐ 2-Deburr if necessary

Deburr 09/8/25

18 9-8-25

(14X)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

18 9-8-25

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

⇒ S 09/14/26

(14)

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50260

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Page 2

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Cust Item ID:

Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Bend as per Dwg D3557

0.00

0.00

SB 09/08/26

14

1

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

27 809/08/26

414

1

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

MD 09/08/27

414

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Qty: 6.00

Required Date: 7/15/09

Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

START TIME:

8:15am

OVEN TEMPERATURE:

8:45am FINISH TIME:

320°F

Powder Coating

⇒ JH 09/08/27 14 d

170

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

BR 09-08-27 (14)

180

Identify as per dwg & Stock Location:

107

0.00



Packaging

Memo

Packaging

19/08/27 (14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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July 14, 2009 10:47:43 AM

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Setup Start



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Stop



Item Name: Bracket

Start Date: 7/15/09 Start Qty: 6.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/28

09-8-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 10:47:42 AM

Page 1

Work Order ID: 50260

Parent Item: D3547-1RevA

Parent Item Name: Bracket

Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S-125		Purchased	No			100	sf	0.0000	0.3347			



2024 T3 .125 sheet



7810-14

HB 9-8-25

M2024T3S-125 9/1/08.08.25

111642

14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	50260
Description: Bracket		Part Number:	D3547-1
Inspection Dwg: D3547 Rev: A		Page 1 of 1	

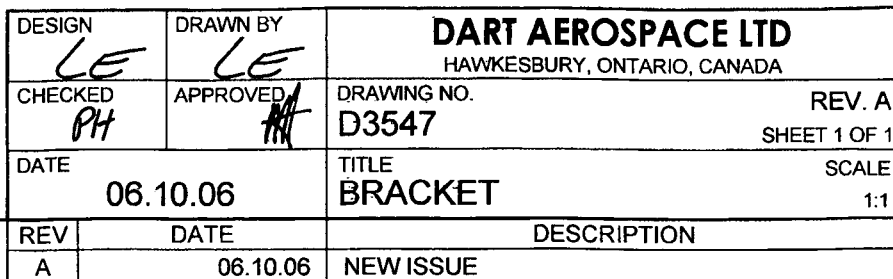
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

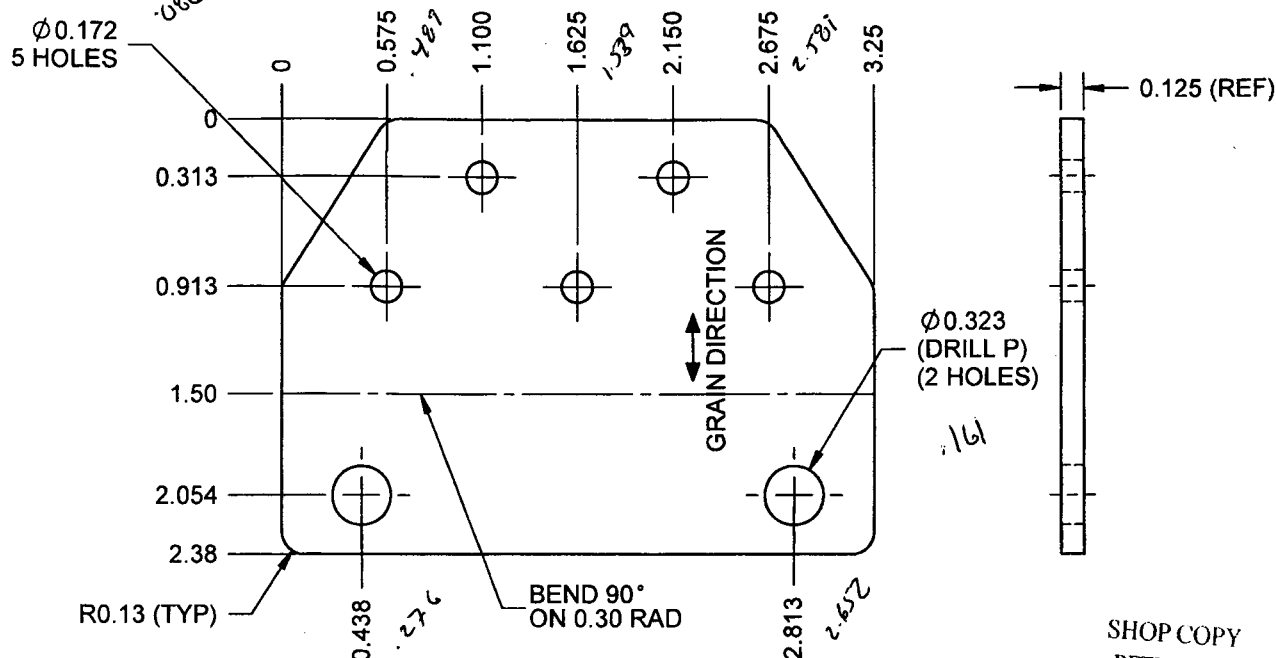
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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0.913	+/-0.010	.913	X			
2.054	+/-0.010	2.053	X			
2.38	+/-0.030	2.387	X			
0.438	+/-0.010	.438	X			
2.813	+/-0.010	2.812	X			
0.575	+/-0.010	.575	X			
1.100	+/-0.010	1.099	X			
1.625	+/-0.010	1.628	X			
2.150	+/-0.010	2.151	X			
2.675	+/-0.010	2.679	X			
3.25	+/-0.030	3.256	X			
Ø0.172	+0.005/-0.001	.173	X			
Ø0.323	+0.006/-0.001	.323	X			
0.125	+/-0.010	.124	X			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-8-25	Date: 02/08/26	Date:	N/A

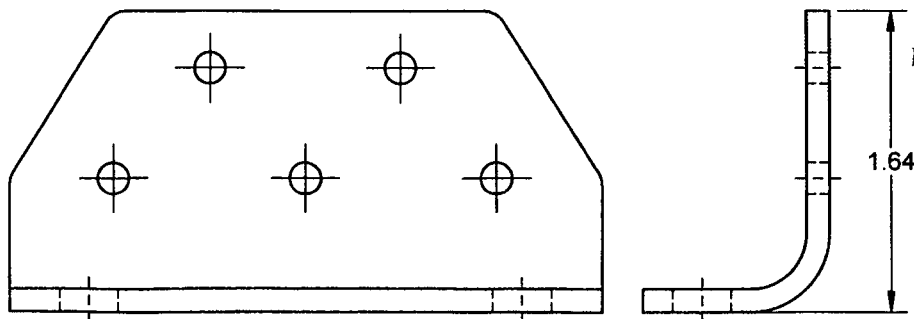
Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	BE



RELEASED
06-10-13



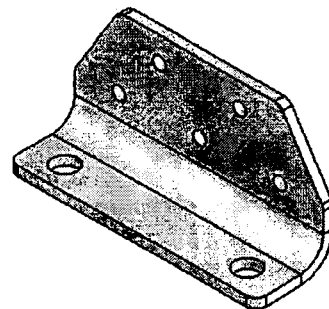
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 50960
MF 09-07-15



D3547-1 BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER QQ-A-250/11
(REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3547-1 USING FINE POINT PERMANENT INK MARKER



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